

Work Order ID 138535

Tuesday, November 03, 2015 3:22:09 PM

138535

Page 1

Item ID: D212-803-115

Revision ID:

Item Name: Left Hand Pilot In Command - Slim Design, Complete 212/412

Start Date: 11/2/2015 Start Qty: 1.00

Required Date: 11/3/2015 Req'd Qty: 1.00

Reference: RMA RA112113

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer: CWILD02

Approvals:

Process Plan: MFDate: 5-11-03 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9728	A								
IIN-D212-803	D								

100

0.00

100

QC

Quality Control

Memo

0.00

INSPECT RA112113 D212-803-115 X 1 B129615

KIT WAS SENT BACK FOR CONTINUOUS IMPROVEMENT

CUSTOMER MADE SOME MODIFICATIONS

GIVE D5046-043 X 1 B116448 TO ENG FOR EVALUATION

SCRAP OR RESTOCK HARDWARE UNDER ORIGINAL NUMBER

SEE ATTACHED LIST MF 15-11-03

110

QC21- Final Inspection - Work Order Release

0.00

110

QC

Quality Control

Memo

0.00

NOV 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
		OTHER : ☐									

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Tuesday, November 03, 2015 3:22:08 PM

Work Order ID: 138535

138535

Parent Item: D212-803-115

D212-803-115

Parent Item Name: Left Hand Pilot In Command - Slim Design, Complete 212/412

Start Date: 11/2/2015

Required Date: 11/3/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.04.17 NEW ISSUE DD VERF:JLM
15.07.03 AS PER ECN15-577 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

27ET51-T		Purchased		No			Each	10.0000		-1			
27ET51-T													
Switch													

**

Location	Loc Qty	Loc Code
Return2015	1	
m128470	1	
ST570	9	
m128470	1	
m130972	2	
m131455	2	
m132261	2	
m132951	2	

MFC 15-11-03

30-037-26		Purchased		No			Each	18.0000		-3			
30-037-26													
Diode Assembly													

**

Location	Loc Qty	Loc Code
ST562	18	
m128898	3	
m133270	15	

MFC 15-11-03

30-037-3		Purchased		No			Each	15.0000		-2			
30-037-3													
Diode Assembly													

**

Location	Loc Qty	Loc Code
ST562	15	
m128898	5	
m133270	10	

MFC 15-11-03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Start Date: 11/2/2015

Required Date: 11/3/2015

Start Qty: 1.00

Required Qty: 1.00

51MX-5-J

Purchased

No

Each

7.0000

-1

51MX-5-J

Switch

Location

Loc Qty

Loc Code

Return2015

1

m129623

1

ST563

6

m129623

1

m133107

5

ME 15-11-03

AN961-6T

NAS1149F0463P

Purchased

No

Each

159.0000

-3

AN961-6T

Washer

Location

Loc Qty

Loc Code

ST326

159

123314

159

Each

0.0000

1

D212-803-115

Manufactured

No

D212-803-115

Left Hand Pilot In Command - Slim Design, Complete 212/412

D5055-9

Manufactured

No

Each

3.0000

-1

D5055-9

Placard

Location

Loc Qty

Loc Code

ST144

3

116630

3

Each

99.0000

-21

M39029/31-240

Purchased

No

M39029/31-240

Pin

Location

Loc Qty

Loc Code

ST556

99

m128793

99

ME 15-11-03

Tuesday, November 03, 2015 3:22:08 PM

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138535

Parent Item: D212-803-115

D212-803-115

Parent Item Name: Left Hand Pilot In Command - Slim Design, Complete 212/412

Start Date: 11/2/2015

Required Date: 11/3/2015

Start Qty: 1.00

Required Qty: 1.00

M39029/32-247

Purchased

No

Each

13.0000

-2

M39029/32-247******

Socket

LocationLoc QtyLoc Code

ST556

13

MF 15-11-03

(M127949)

13

Each

106.0000

-21

M39029/32-259

Purchased

No

M39029/32-259******

Socket

LocationLoc QtyLoc Code

ST556

106

MF 15-11-03

(m128795)

106

Each

218.0000

-3

MS21042L06

Purchased

No

MS21042L06******

Nut

LocationLoc QtyLoc Code

ST304

212

m132803

64

m133316

48

m133363

100

ST305

6

(m130325)

3

m131317

3

MF 15-11-03

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Start Date: 11/2/2015

Required Date: 11/3/2015

Start Qty: 1.00

Required Qty: 1.00

MS21919WDG19

Purchased

No

Each

6.0000

-1

MS21919WDG19******

Clamp

LocationLoc QtyLoc Code

ST296

6

m126741

3

m132344

3

JMF 15-11-03

MS24523-27

Purchased

No

Each

4.0000

-1

MS24523-27******

Switch

LocationLoc QtyLoc Code

ST294

4

123348

3

123247

1

JMF 15-11-03

MS27039-1-07

Purchased

No

Each

439.0000

-1

MS27039-1-07******

Screw

LocationLoc QtyLoc Code

GA

334

125654

334

ST286

105

m127813

97

m130388

8

JMF 15-11-03

MS27212-1-3

Purchased

No

Each

5.0000

-1

MS27212-1-3******

Terminal Board

LocationLoc QtyLoc Code

Return2015

1

M127977

1

ST280

4

M127977

4

JMF 15-11-03

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Root Cause				FAULT CATEGORY			
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Start Date: 11/2/2015

Required Date: 11/3/2015

Start Qty: 1.00

Required Qty: 1.00

MS3120E16-99S

Purchased

No

Each

7.0000

-1

MS3120F16-99S******

Socket

LocationLoc QtyLoc Code

ST

1

m128898

1

ST272

6

m133107

6

Each

9.0000

-2

MS3126E16-99P

Purchased

No

MS3126F16-99P******

Socket

LocationLoc QtyLoc Code

ST272

9

m128898

3

m133107

6

Each

18.0000

-1

MS3373-A1

Purchased

No

MS3373-A1******

Strip

LocationLoc QtyLoc Code

ST277

18

m123390

1

m126765

2

m132700

15

Each

121.0000

-5

MS35206-226

Purchased

No

MS35206-226******

Screw

LocationLoc QtyLoc Code

ST277

121

m127831

121

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 138535

138535

Parent Item: D212-803-115

D212-803-115

Parent Item Name: Left Hand Pilot In Command - Slim Design, Complete 212/412

Start Date: 11/2/2015

Required Date: 11/3/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

Each

797.0000

-2

NAS1149D0363.J******

Washer

LocationLoc QtyLoc Code

CA

246

m130799

246

GA

236

m130799

236

ST269

315

m126319

7

m128429

2

m131618

1

m132317

10

m132677

42

m133031

253

MF 15-10-03

NAS1197-6

Purchased

No

Each

155.0000

-5

NAS1197-6******

Washer

LocationLoc QtyLoc Code

ST267

155

m123190

9

m128976

26

m128993

120

MF 15-11-03

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Shop Packet Print

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

RA112113

Received: September 25
Inspected: October 30, 2015

CUSTOMER: Wildcat Helicopter
CUSTOMER CONTACT: Mitch
SHIPPED FROM:

Instructions for RA112113 D212-803-115 B129614 CHG 001

- Sent back for continuous improvement
- Customer made some modification on D5046-043
- See attachment for disposition of parts
- Give D5046-043 B116448 to engineering for evaluation

Time Estimate: 2 hours

Departments Required: Quality, stores, engineering

Pictures Attached: yes

QTY INSPECTED: 1x D212-803-115 B129614 CHG 001

THIS INSTRUCTION SHEET MUST BE
ATTACHED TO THE RESTOCKING
WORK ORDER AT ALL TIMES!!!!

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																														
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Disposition of parts

Parent Item ID	Lot Qty	Lot Nbr	stock	scrap
MS27039-1-07	-1	m127813	X	
MS21042L3	-1	M128401	X	
D5046-043	-1	116448		X *
M39029/32-247	-2	M127949	X	
NAS1149D0363J	-2	m128429	X	
MS3126E16-99P	-2	m128898	X	
MS3120E16-99S	-1	m128898	X	
MS27212-1-3	-1	M127977	X	
AN961-6T	-3	123314	X	
51MXY-5-J	-1	m129623	X	
MS3373-A1	-1	m123390	X	
MS3373-A1	-2	m126765	X	
MS24693-S7	-2	m129278		X
MS21919WDG19	-1	m126741	X	
MS21919WDG10	-1	m128401	X	
MS21044N04	-2	125445	X	
M39029/32-259	-21	m128795	X	
M39029/31-240	-21	m128795	X	
M39029/31-228	-2	M127949		X
D5055-9	-1	116630	X	
D5055-7	-1	116629		X
D4411-7	-1	117559		X
30-037-3	-2	m128898	X	
30-037-26	-3	m128898	X	
D5049-1	-1	119087		X
D5055-3	-1	116627		X
D5055-5	-1	116628		X
MS21042L06	-3	m130325	X	
MS35206-226	-5	m127831	X	
NAS1197-6	-5	m128976	X	
MS24523-27	-1	125247	X	
27ET51-T	-1	m128470	X	

* Give too engineering

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					